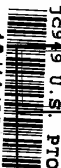


10/19/00



JCS 49 U.S. PTO

## PATENT APPLICATION TRANSMITTAL LETTER

(Large Entity)

Docket No.  
GL-21 (GL-00-5)

TO THE ASSISTANT COMMISSIONER FOR PATENTS

Transmitted herewith for filing under 35 U.S.C. 111 and 37 C.F.R. 1.53 is the patent application of:

Carlo Neri and Corrado Callierotti

For: MIXTURES OF ADDITIVES FOR ORGANIC POLYMERS IN GRANULAR FORM

(This appln. is based on Ital. Appln. Ser. No. MI99A 002205, filed 10/21/99, the priority of which is claimed.)

Enclosed are:

- ☒ Certificate of Mailing with Express Mail Mailing Label No. **EK724632624US**
- ☐ sheets of drawings.
- ☒ A certified copy of a **Ital. Appln. MI99A 002205** application.
- ☐ Declaration ☐ Signed. ☐ Unsigned.
- ☐ Power of Attorney
- ☐ Information Disclosure Statement
- ☐ Preliminary Amendment
- ☒ Other: **Return Postal Card**

## CLAIMS AS FILED

For	#Filed	#Allowed	#Extra	Rate	Fee
<b>Total Claims</b>	17	- 20 =	0	x \$18.00	\$0.00
<b>Indep. Claims</b>	3	- 3 =	0	x \$80.00	\$0.00
<b>Multiple Dependent Claims (check if applicable)</b> <input type="checkbox"/>					\$0.00
<b>BASIC FEE</b>					\$710.00
<b>TOTAL FILING FEE</b>					\$710.00

- ☐ A check in the amount of \_\_\_\_\_ to cover the filing fee is enclosed.
- ☒ The Commissioner is hereby authorized to charge and credit Deposit Account No. **50-0935** as described below. A duplicate copy of this sheet is enclosed.
- ☒ Charge the amount of **\$710.00** as filing fee.
- ☒ Credit any overpayment.
- ☒ Charge any additional filing fees required under 37 C.F.R. 1.16 and 1.17.
- ☐ Charge the issue fee set in 37 C.F.R. 1.18 at the mailing of the Notice of Allowance, pursuant to 37 C.F.R. 1.311(b).

Dated: October 14, 2000

  
Signature

Michael W. Ferrell - Reg. No. 31,158  
 Ferrell & Ferrell, L.L.P.  
 90 Crystal Run Road, Suite 401  
 Middletown, New York 10941  
 Telephone: (703) 266-3000  
 Facsimile: (703) 266-6000

CC:

 JCS 49 U.S. PTO  
 09/16/2005  
 10/19/00

5

MIXTURES OF ADDITIVES FOR ORGANIC POLYMERS IN GRANULAR FORM.

The present invention relates to mixtures of additives for organic polymers in granular form.

More specifically, the present invention relates to mixtures of additives for organic polymers in granular form comprising one or more stabilizers for organic polymers, one or more organic or inorganic pigments and/or one or more dyes, obtained by extrusion at a temperature capable of enabling the partial or total melting of the lowest-melting component and their use in the stabilization and dyeing of organic polymers.

The present invention also relates to the polymeric compositions stabilized and dyed with the above mixtures and the end-products obtained by their processing.

As is known, most additives for organic polymers are in powder form. These powders, when used during the processing of organic polymers, have the disadvantage of being dispersed in the air and can damage the health of the

operators as well as creating safety problems due to the possibility of explosions.

Another drawback in the use of additives in powder form is the possibility of their thickening in the feeding  
5 hoppers, thus obtaining inconstant dosages of the additives in the polymer.

The use of additives in powder form, moreover, makes it difficult to obtain complete homogenization between the various components of the mixture and consequently  
10 between these and the organic polymer to be stabilized, thus causing heterogeneity in the stabilization.

It is known that there is a growing demand on the market for additives in solid form.

For this purpose, resort has been made to granulation systems using dry compacting machines or pellet  
15 mills, or using so-called "masterbatches" containing the organic polymer to be stabilized and one or more additives in a quantity ranging from 2.5% to 60%.

Solid stabilizing mixtures for organic polymers can  
20 be obtained as described, for example, in European patent EP 565,184: the solid mixtures obtained consist of two or more stabilizers for organic polymers but no reference is made to the possibility of introducing organic or inorganic pigments and/or one or more dyes, into these mix-  
25 tures.

As organic or inorganic pigments and dyes are also generally in powder form, their use in organic polymers has the same disadvantages described above.

U.S. patent 4,604,100 describes a process for the  
5 preparation of formulations of dyes in granular form using polyethylene glycol as carrier.

U.S. patent 4,194,921, on the other hand, describes a process for obtaining pigments in the form of beads without powders: also in this case the process is carried  
10 out in the presence of carriers.

The Applicant has now found that it is possible to obtain mixtures of additives for organic polymers in granular form comprising one or more stabilizers for organic polymers, one or more organic or inorganic pigments  
15 and/or one or more dyes, by means of extrusion at a temperature capable of enabling the partial or total melting of the lowest-melting component. The extrusion temperature is much lower than the temperature at which the additives are processed in the case of masterbatches, and  
20 the additives used are therefore subjected to less thermal stress. In addition, carriers are not used, thus avoiding the introduction of foreign components into the organic polymer to which the mixtures are to be added.

An object of the present invention therefore relates  
25 to mixtures of additives in granular form comprising:

- one or more stabilizers for organic polymers;
- one or more organic or inorganic pigments; and/or
- one or more dyes;

obtained by extrusion at a temperature capable of enabling the partial or total melting of the lowest-melting component.

Stabilizers for organic polymers useful for the purposes of the present invention are selected from the following groups:

10 1. Antioxidants

1.1 Alkylated monophenols such as, for example: 2,6-di-t-butyl-4-methylphenol; 2-t-butyl-4,6-dimethylphenol; 2,6-di-t-butyl-4-ethylphenol; 2,6-di-t-butyl-4-n-butylphenol; 2,6-di-t-butyl-4-isobutylphenol; 2,6-dicyclopentyl-4-methylphenol; 2-( $\alpha$ -methylcyclohexyl)-4,6-dimethylphenol; 2,6-dioctadecyl-4-methylphenol; 2,4,6-tricyclohexylphenol; 2,6-di-t-butyl-4-methoxymethylphenol; nonylphenols with a linear or branched alkyl chain such as, for example, 2,6-di-nonyl-4-methylphenol; 2,4-dimethyl-6-(1'-methylundec-1'-yl)phenol; 2,4-dimethyl-6-(1'-methylheptadec-1'-yl)phenol; 2,4-dimethyl-6-(1'-methyltridec-1'-yl)phenol; and their mixtures.

1.2 Alkylthiomethylphenols such as, for example: 2,4-di-octylthiomethyl-6-t-butylphenol; 2,4-di-octylthiomethyl-6-methylphenol; 2,4-di-octylthiomethyl-6-ethylphenol; 2,6-

didodecylthiomethyl-4-nonylphenol.

1.3 Hydroquinones and alkylated hydroquinones such as, for example: 2,6-di-t-butyl-4-methoxyphenol; 2,5-di-t-butylhydroquinone; 2,5-di-t-amylhydroquinone; 2,6-di-phenyl-4-octadecyloxyphenol; 2,6-di-t-butylhydroquinone; 2,5-di-t-butyl-4-hydroxyanisol; 3,5-di-t-butyl-4-hydroxyanisol; 3,5-di-t-butyl-4-hydroxyphenyl stearate; bis(3,5-di-t-butyl-4-hydroxyphenyl)adipate.

1.4 Tocopherols such as, for example:  $\alpha$ -tocopherol,  $\beta$ -tocopherol,  $\gamma$ -tocopherol,  $\delta$ -tocopherol and their mixtures (Vitamin E).

1.5 Hydroxylated thiodiphenyl ethers such as, for example 2,2'-thiobis-(6-t-butyl-4-methylphenol); 2,2'-thiobis-(4-octylphenol); 4,4'-thiobis-(6-t-butyl-3-methylphenol); 4,4'-thiobis-(6-t-butyl-2-methylphenol); 4,4'-thiobis-(3,6-di-s-amylphenol); 4,4'-bis-(2,6-dimethyl-4-hydroxyphenyl)disulfide.

1.6 Alkylidene-bisphenols such as, for example: 2,2'-methylenebis-(6-t-butyl-4-methylphenol); 2,2'-methylenebis-(6-t-butyl-4-ethylphenol); 2,2'-methylenebis[4-methyl-6-( $\alpha$ -methylcyclohexyl)phenol]; 2,2'-methylenebis(4-methyl-6-cyclohexylphenol); 2,2'-methylenebis(6-nonyl-4-methylphenol); 2,2'-methylenebis(4,6-di-t-butylphenol); 2,2'-ethylenidene-bis(4,6-di-t-butylphenol); 2,2'-ethylenidenebis(6-t-butyl-4-isobutylphenol); 2,2'-methylen-

bis[6-( $\alpha$ -methylbenzyl)-4-nonylphenol]; 2,2'-methylene-  
bis[6-( $\alpha,\alpha$ -dimethylbenzyl)-4-nonylphenol]; 4,4'-methyl-  
enebis(2,6-di-*t*-butylphenol); 4,4'-methylenebis(6-*t*-but-  
yl-2-methylphenol); 1,1-bis(5-*t*-butyl-4-hydroxy-2-methyl-  
5 phenyl)butane; 2,6-bis(3-*t*-butyl-5-methyl-2-hydroxy-  
benzyl)-4-methylphenol; 1,1,3-tris-(5-*t*-butyl-4-hydroxy-  
2-methylphenyl)butane; 1,1-bis(5-*t*-butyl-4-hydroxy-2-  
methylphenyl)-3-*n*-dodecyl-mercaptobutane; ethyleneglycol  
bis[3,3-bis-(3'-*t*-butyl-4'-hydroxyphenyl)butyrate]; bis-  
10 (3-*t*-butyl-4-hydroxy-5-methylphenyl)dicyclopentadiene;  
bis[2-(3'-*t*-butyl-2'-hydroxy-5'-methylbenzyl)-6-*t*-butyl-  
4-methylphenyl]terephthalate; 1,1-bis(3,5-dimethyl-2-hyd-  
roxyphenyl)butane; 2,2-bis(3,5-di-*t*-butyl-4-hydroxy-  
phenyl)propane; 2,2-bis(5-*t*-butyl-4-hydroxy-2-methyl-  
15 phenyl)-4-*n*-dodecylmercaptobutane; 1,1,5,5-tetra(5-*t*-but-  
yl-4-hydroxy-2-methylphenyl)pentane.

1.7 Benzyl compounds containing O, N or S such as, for  
example: 3,5,3',5'-tetra-*t*-butyl-4,4'-dihydroxydibenzyl-  
ether; octadecyl-4-hydroxy-3,5-dimethylbenzylmercapto-  
20 acetate; tridecyl-4-hydroxy-3,5-di-*t*-butyl-benzylmer-  
captoacetate; tris(3,5-di-*t*-butyl-4-hydroxybenzyl)amine;  
bis(4-*t*-butyl-3-hydroxy-2,6-dimethylbenzyl)dithiotereph-  
thalate; bis(3,5-di-*t*-butyl-4-hydroxybenzyl)sulfide;  
iso-octyl-3,5-di-*t*-butyl-4-hydroxybenzylmercaptoacetate.  
25 1.8 Hydroxybenzylated malonates such as, for example:

di-octadecyl-2,2-bis(3,5-di-t-butyl-2-hydroxybenzyl)malonate; di-octadecyl-2-(3-t-butyl-4-hydroxy-5-methylbenzyl)-malonate; didodecylmercaptoethyl-2,2-bis(3,5-di-t-butyl-4-hydroxybenzyl)malonate; bis[4-(1,1,3,3-tetramethyl-5 butyl)phenyl]-2,2-bis(3,5-di-t-butyl-4-hydroxybenzyl)-malonate.

1.9 Aromatic hydroxybenzyl compounds such as, for example: 1,3,5-tris(3,5-di-t-butyl-4-hydroxybenzyl)-2,4,6-trimethylbenzene; 1,4-bis-(3,5-di-t-butylhydroxybenzyl)-10 2,3,5,6-tetramethylbenzene; 2,4,6-tris(3,5-di-t-butyl-4-hydroxybenzyl)phenol.

1.10 Triazine compounds such as, for example: 2,4-bis(octylmercapto)-6-(3,5-di-t-butyl-4-hydroxyanilino)-1,3,5-triazine; 2-octylmercapto-4,6-bis(3,5-di-t-butyl-4-15 hydroxyanilino)-1,3,5-triazine; 2-octylmercapto-4,6-bis-(3,5-di-t-butyl-4-hydroxyphenoxy)-1,3,5-triazine; 2,4,6-tris-(3,5-di-t-butyl-4-hydroxyphenoxy)-1,2,3-triazine; 1,3,5-tris(3,5-di-t-butyl-4-hydroxybenzyl)isocyanurate; 1,3,5-tris(4-t-butyl-3-hydroxy-2,6-dimethylbenzyl)iso-20 cyanurate; 2,4,6-tris-(3,5-di-t-butyl-4-hydroxyphenylethyl)-1,3,5-triazine; 1,3,5-tris(3,5-di-t-butyl-4-hydroxyphenylpropionyl)hexahydro-1,3,5-triazine; 1,3,5-tris(3,5-dicyclohexyl-4-hydroxybenzyl)isocyanurate.

1.11 Benzylphosphonates such as, for example: dimethyl-25 2,5-di-t-butyl-4-hydroxybenzylphosphonate; diethyl-3,5-



di-t-butyl-4-hydroxybenzylphosphonate; dioctadecyl-3,5-di-t-butyl-4-hydroxybenzylphosphonate; dioctadecyl-5-t-butyl-4-hydroxy-3-methylbenzylphosphonate; calcium salts of monoethyl ester of 3,5-di-t-butyl-4-hydroxybenzylphosphonic acid.

1.12 Acylaminophenols such as, for example: 4-hydroxy-lauranilide; 4-hydroxystearanilide; octyl-N-(3,5-di-t-butyl-4-hydroxyphenyl)carbamate.

1.13 Esters of  $\beta$ -(3,5-di-t-butyl-4-hydroxyphenyl)propionic acid with monohydric or polyhydric alcohols such as, for example: methanol, ethanol, n-octanol, i-octanol, octadecanol, 1,6-hexanediol, 1,9-nonanediol, ethylene glycol, 1,2-propanediol, neopentyl glycol, thiodiethylene glycol, diethylene glycol, triethylene glycol, pentaerythritol, tris(hydroxyethyl) isocyanurate, N,N'-bis(hydroxyethyl)oxalamide, 3-thioundecanol, 3-thio-pentadecanol, trimethylhexanediol, trimethylolpropane, 4-hydroxymethyl-1-phospho-2,6,7-trioxabicyclo[2.2.2]-octane.

1.14 Esters of  $\beta$ -(5-t-butyl-4-hydroxy-3-methylphenyl)propionic acid with monohydric or polyhydric alcohols such as, for example: methanol, ethanol, n-octanol, i-octanol, octadecanol, 1,6-hexanediol, 1,9-nonanediol, ethylene glycol, 1,2-propanediol, neopentyl glycol, thiodiethylene glycol, diethylene glycol, triethylene glycol, pentaerythritol, tris(hydroxyethyl)isocyanurate, N,N'-bis-

(hydroxyethyl)oxamide, 3-thioundecanol, 3-thiopentadecanol, trimethylhexanediol, trimethylolpropane, 4-hydroxymethyl-1-phospho-2,6,7-trioxabicyclo[2.2.2]-octane.

1.15 Esters of  $\beta$ -(3,5-dicyclohexyl-4-hydroxyphenyl)propionic acid with monohydric or polyhydric alcohols

5 such as, for example: methanol, ethanol, n-octanol, i-octanol, octadecanol, 1,6-hexanediol, 1,9-nonanediol, ethylene glycol, 1,2-propanediol, neopentyl glycol, thiodiethylene glycol, diethylene glycol, triethylene glycol, pentaerythritol, tris(hydroxyethyl)isocyanurate, N,N'-bis(hydroxyethyl)oxamide, 3-thioundecanol, 3-thiopentadecanol, trimethylhexanediol, trimethylolpropane, 4-hydroxymethyl-1-phospho-2,6,7-trioxabicyclo[2.2.2]-octane.

15 1.16 Esters of (3,5-di-t-butyl-4-hydroxyphenyl)acetic acid with monohydric or polyhydric alcohols

such as, for example: methanol, ethanol, n-octanol, i-octanol, octadecanol, 1,6-hexanediol, 1,9-nonanediol, ethylene glycol, 1,2-propanediol, neopentyl glycol, thiodiethylene glycol, diethylene glycol, triethylene glycol, pentaerythritol, tris(hydroxyethyl) isocyanurate, N,N'-bis(hydroxyethyl)oxamide, 3-thioundecanol, 3-thiopentadecanol, trimethylhexanediol, trimethylolpropane, 4-hydroxymethyl-1-phospho-2,6,7-trioxabicyclo[2.2.2]-octane.

25 1.17 Amides of  $\beta$ -(3,5-di-t-butyl-4-hydroxyphenyl)prop-

ionic acid such as, for example: N,N'-bis(3,5-di-t-butyl-4-hydroxyphenylpropionyl)hexamethylenediamide; N,N'-bis(3,5-di-t-butyl-4-hydroxyphenylpropionyl)trimethylenediamide; N,N'-bis(3,5-di-t-butyl-4-hydroxyphenylpropionyl)hydrazide; N,N'-bis[2-(3-[3,5-di-t-butyl-4-hydroxyphenyl]propionyl-oxy)ethyl]oxamide (Naugard® XL-1 of Uniroyal).

#### 1.18 Ascorbic acid (vitamin C).

1.19 Amine antioxidants such as, for example, N,N'-diisopropyl-p-phenylenediamine; N,N'-di-s-butyl-p-phenylenediamine; N,N'-bis(1,4-dimethylpentyl)-p-phenylenediamine; N,N'-bis(1-ethyl-3-methylpentyl)-p-phenylenediamine; N,N'-bis(1-methylheptyl)-p-phenylenediamine; N,N'-dicyclohexyl-p-phenylenediamine; N,N'-diphenyl-p-phenylenediamine; N,N'-bis(2-naphthyl)-p-phenylenediamine; N-isopropyl-N'-phenyl-p-phenylenediamine; N-(1,3-dimethylbutyl)-N'-phenyl-p-phenylenediamine; N-(1-methylheptyl)-N'-phenyl-p-phenylenediamine; N-cyclohexyl-N'-phenyl-p-phenylenediamine; 4-(p-toluenesulfamoyl)di-phenylamine; N,N'-dimethyl-N,N'-di-s-butyl-p-phenylenediamine; diphenylamine; N-allyldiphenylamine; 4-isopropoxydiphenylamine; N-phenyl-1-naphthylamine; N-(4-t-octylphenyl)-1-naphthylamine; N-phenyl-2-naphthylamine; diphenylamine octylate such as, for example, p,p'-di-t-octyldiphenylamine; 4-n-butylaminophenol; 4-butirylami-

nophenol; 4-nonanoylamino-phenol; 4-dodecanoylamino-phenol;  
4-octadecanoylamino-phenol; bis(4-methoxyphenyl)amine;  
2,6-di-t-butyl-4-dimethylaminomethylphenol; 2,4'-diamino-  
diphenylmethane; 4,4'-diaminodiphenylmethane; N,N,N',N'-  
5 tetramethyl-4,4'-diaminodiphenylmethane; 1,2-bis[(2-meth-  
ylphenyl)amino]ethane; 1,2-bis(phenylamino)propane; (o-  
tolyl)biguanide; bis[4-(1',3'-dimethylbutyl)phenyl]amine;  
N-phenyl-1-naphthylamine t-octylate; mixture of mono- and  
dialkylated t-butyl/t-octyldiphenylamines; mixture of mo-  
10 no- and dialkylated nonyldiphenylamines; mixture of mono-  
and dialkylated dodecyldiphenylamines; mixture of mono-  
and dialkylated isopropyl/isohexyldiphenylamines; mixture  
of mono- and dialkylated t-butyl-diphenylamines; 2,3-  
dihydro-3,3-dimethyl-4H-1,4-benzothiazine; phenothiazine;  
15 mixture of mono- and dialkylated t-butyl/t-octyl-  
phenothiazines; mixture of mono- and dialkylated t-octyl-  
phenothiazines; N-allyl-phenothiazine; N,N,N',N'-tetra-  
phenyl-1,4-diaminobut-2-ene; N,N-bis(2,2,6,6-tetrameth-  
yl-piperid-4-yl)hexamethylenediamine; bis-(2,2,6,6-  
20 tetramethylpiperidin-4-yl)sebacate; 2,2,6,6-tetramethyl-  
piperidin-4-one; 2,2,6,6-tetramethylpiperidin-4-ol.

## 2. UV ray and light stabilizers.

2.1 Derivatives of 2-(2'-hydroxyphenyl)benzotriazoles  
such as, for example: 2-(2'-hydroxy-5'-methylphenyl)-  
25 benzotriazole; 2-(3',5'-di-t-butyl-2'-hydroxyphenyl)-

benzotriazole; 2-(5'-t-butyl-2'-hydroxyphenyl)benzotriazole; 2-[2'-hydroxy-5'-(1,1,3,3-tetramethylbutyl)phenyl]benzotriazole; 2-(3',-5'-di-t-butyl-2'-hydroxyphenyl)-5-chlorobenzotriazole; 2-(3'-t-butyl-2'-hydroxy-5'-methylphenyl)-5-chlorobenzotriazole; 2-(3'-s-butyl-5'-t-butyl-2'-hydroxyphenyl)benzotriazole; 2-(2'-hydroxy-4'-octyloxyphenyl)benzotriazole; 2-(3',5'-di-t-amyl-2'-hydroxyphenyl)benzotriazole; 2-[3',5'-bis( $\alpha,\alpha$ -dimethylbenzyl)-2'-hydroxyphenyl]benzotriazole; 2-[3'-t-butyl-2'-hydroxy-5'-(2-octyloxy-carbonyl-ethyl)phenyl]-5-chlorobenzotriazole, 2-[3'-t-butyl-5'-(2-(2-ethylhexyloxy)carbonyl-ethyl)-2'-hydroxyphenyl]-5-chlorobenzotriazole, 2-[3'-t-butyl-2'-hydroxy-5'-(2-methoxycarbonyl-ethyl)phenyl]-5-chlorobenzotriazole, 2-[3'-t-butyl-2'-hydroxy-5'-(2-methoxycarbonyl-ethyl)phenyl]benzotriazole, 2-[3'-t-butyl-2'-hydroxy-5'-(2-octyloxy-carbonyl-ethyl)phenyl]-benzotriazole, 2-[3'-t-butyl-5'-(2-(2-ethylhexyloxy)carbonyl-ethyl)-2'-hydroxyphenyl]benzotriazole, 2-(3'-dodecyl-2'-hydroxy-5'-methylphenyl)benzotriazole; 2-[3'-t-butyl-2'-hydroxy-5'-(2-iso-octyloxy-carbonyl-ethyl)phenyl]benzotriazole, 2,2'-methylene-bis[4-(1,1,3,3-tetramethylbutyl)-6-benzotriazol-2-yl-phenol]; transesterification product of 2-[3'-t-butyl-5'-(2-methoxycarbonyl-ethyl)-2'-hydroxyphenyl]-2H-benzotriazole with polyethylene glycol

300;

[R-CH<sub>2</sub>CH<sub>2</sub>-COO(CH<sub>2</sub>)<sub>3</sub>]-]2- wherein R = 3'-t-butyl-4-hydroxy-5'-2H-benzotriazol-2-yl-phenyl; 2-[2'-hydroxy-3'-( $\alpha$ , $\alpha$ -dimethylbenzyl)-5'-(1,1,3,3-tetramethylbutyl)phenyl]benzotriazole; 2-[2'-hydroxy-3'-(1,1,3,3-tetramethylbutyl)-5'-( $\alpha$ , $\alpha$ -dimethylbenzyl)phenyl]benzotriazole.

2.2 Derivatives of 2-hydroxybenzophenones such as, for example: 4-hydroxy-; 4-methoxy-; 4-octyloxy-; 4-decyloxy-; 4-dodecyloxy-; 4-benzyloxy-; 4,2',4'-trihydroxy-; 2'-hydroxy-4,4'-dimethoxy.

2.3 Esters of benzoic acids, optionally substituted, such as, for example: phenyl salicylate, 4-t-butylphenyl salicylate, octylphenyl salicylate, benzoyl resorcinol, bis(4-t-butylbenzoyl)resorcinol, dibenzoyl resorcinol, 2,4-di-t-butylphenyl-3,5-di-t-butyl-4-hydroxybenzoate, hexadecyl-3,5-di-t-butyl-4-hydroxybenzoate, octadecyl-3,5-di-t-butyl-4-hydroxybenzoate, 2-methyl-4,6-di-t-butylphenyl-3,5-di-t-butyl-4-hydroxybenzoate.

2.4 Acrylates such as, for example, ethyl or isoctyl  $\alpha$ -cyano- $\beta$ , $\beta$ -diphenylacrylate; methyl  $\alpha$ -carbomethoxycinnamate, methyl or butyl  $\alpha$ -cyano- $\beta$ -methyl-p-methoxycinnamate, methyl  $\alpha$ -carbomethoxy-p-methoxycinnamate, N-( $\beta$ -carbomethoxy- $\beta$ -cyanovinyl)-2-methylindoline.

2.5 Nickel compounds such as, for example, Ni complexes of 2,2'-thio-bis-[4-(1,1,3,3-tetramethylbutyl)phenol], for example 1:1 or 1:2 complexes, with or without addi-

tional binders such as n-butylamine, triethanolamine or N-cyclohexyldiethanolamine, nickel dibutyldithiocarbamate, nickel salts of monoalkyl esters of 4-hydroxy-3,5-di-t-butyl-benzyl-phosphonic acid, such as methyl or ethyl esters, nickel complexes with ketoximes such as 2-hydroxy-4-methylphenyl undecylketoxime, nickel complexes of 1-phenyl-4-lauroyl-5-hydroxypyrazol with or without additional binders.

2.6 Sterically hindered amines and their N-alkoxy derivatives such as, for example: poly-methylpropyl-3-oxy-[4-(2,2,6,6-tetramethyl)piperidiny]siloxane, polymethylpropyl-3-oxy-[4-(1,2,2,6,6-pentamethyl)piperidiny]siloxane, bis-(2,2,6,6-tetramethyl-4-piperidiny)sebacate; bis(2,2,6,6-tetramethyl-4-piperidiny)succinate; bis(1,2,2,6,6-pentamethyl-4-piperidiny)sebacate; bis(1-octyloxy-2,2,6,6-tetramethyl-4-piperidiny)sebacate; bis(1,2,2,6,6-pentamethyl-4-piperidyl)n-butyl-3,5-di-t-butyl-4-hydroxybenzylmalonate; condensation product between 1-(2-hydroxyethyl)-2,2,6,6-tetra-4-hydroxypiperidine and succinic acid; condensation product, linear or cyclic, between N,N'-bis(2,2,6,6-tetramethyl-4-piperidyl)hexamethylenediamine and 4-t-octylamino-2,6-dichloro-1,3,5-s-triazine; tris(2,2,6,6-tetramethyl-4-piperidyl) nitri-lotriacetate; tetrakis(2,2,6,6-tetramethyl-4-piperidiny)-1,2,3,4-butanetetracarboxylate; 1,1'-(1,2-ethanodiyl)bis

(3,3,5,5-tetramethylpiperazinone; 4-benzoyl-2,2,6,6-tetramethylpiperidine; 4-stearyloxy-2,2,6,6-tetramethylpiperidine; bis(1,2,2,6,6-pentamethylpiperidyl)-2-n-butyl-2-(2-hydroxy-3,5-di-t-butylbenzyl)malonate; 3-n-octyl-  
5 7,7,9,9-tetramethyl-1,3,8-triazaspiro[4.5]decan-2,4-dione; bis(1-octyloxy-2,2,6,6-tetramethylpiperidyl)sebacate; bis(1-octyloxy-2,2,6,6-tetramethylpiperidyl)succinate; condensation product, linear or cyclic, between N,N'-bis(2,2,6,6-tetramethyl-4-piperidyl)hexamethylene-  
10 diamine and 4-morpholine-2,6-dichloro-1,3,5-triazine; condensation product between 2-chloro-4,6-di-(4-n-butylamino-2,2,6,6-tetramethylpiperidyl)-1,3,5-triazine and 1,2-bis(3-aminopropylamino)ethane; condensation product between 2-chloro-4,6-di-(4-n-butylamino-  
15 1,2,2,6,6-pentamethylpiperidyl)-1,3,5-triazine and 1,2-bis(3-aminopropylamino)ethane; 8-acetyl-3-dodecyl-7,7,9,9-tetramethyl-1,3,8-triazaspiro-[4.5]decano-2,4-dione; 3-dodecyl-1-(2,2,6,6-tetramethyl-4-piperidyl)pyrrolidin-2,5-dione; 3-dodecyl-1-(1,2,2,6,6-pentamethyl-4-piperidyl)pyrrolidin-2,5-dione; mixture of 4-hexadecyloxy-  
20 and 4-stearyloxy-2,2,6,6-tetramethylpiperidine; condensation product between N,N'-bis(2,2,6,6-tetramethyl-4-piperidyl)hexamethylenediamine and 4-cyclohexylamino-2,6-dichloro-1,3,5-triazine; condensation product between  
25 1,2-bis(3-aminopropylamino)ethane and 2,4,6-trichloro-



1,3,5-triazine, as well as 4-butylamino-2,2,6,6-tetramethylpiperidine (CAS Reg. Nr. [136504-96-6]; N-(2,2,6,6-tetramethyl-4-piperidyl)-n-dodecylsuccinimide; N-(1,2,2,6,6-pentamethyl-4-piperidyl)-n-dodecylsuccin-  
5 imide; 2-undecyl-7,7,9,9-tetramethyl-1-oxa-3,8-diaza-4-oxospiro[4,5]decane; reaction product between 7,7,9,9-tetramethyl-2-cycloundecyl-1-oxa-3,8-diaza-4-oxospiro[4,5]decane and epichlorohydrin; 1,1-bis(1,2,2,6,6-pentamethyl-4-piperidyl)oxycarbonyl)-2-(4-methoxyphenyl)-  
10 ethene; N,N'-bis-formyl-N,N'-bis(2,2,6,6-tetramethyl-4-piperidyl)hexamethylenediamine; diester of 4-methoxymethylenemalonic acid with 1,2,2,6,6-pentamethyl-4-hydroxypiperidine; reaction product of maleic anhydride/ $\alpha$ -olefin copolymer with 2,2,6,6-tetramethyl-4-  
15 aminopiperidine or with 1,1,2,2,6-pentamethyl-4-aminopiperidine.

2.7 Oxamides such as, for example: 4,4'-dioctyloxyoxanilide; 2,2'-diethoxyoxanilide; 2,2'-dioctyloxy-5,5'-di-t-butoxanilide; 2,2'-didodecyloxy-5,5'-di-t-butoxanil-  
20 ide; 2-ethoxy-2'-ethyloxanilide; N,N'-bis(3-dimethylaminopropyl)oxamide; 2-ethoxy-5-t-butyl-2'-ethoxanilide and its mixtures with 2-ethoxy-2'-ethyl-5,4'-di-t-butoxanilide; and mixtures of disubstituted ortho- and para-methoxy oxanilides and mixtures of disubstituted or-  
25 tho and para-ethoxy oxanilides.

2.8 2-(2-hydroxyphenyl)-1,3,5-triazines such as, for example: 2,4,6-tris(2-hydroxy-4-octyloxyphenyl)-1,3,5-triazine; 2-(2-hydroxy-4-octyloxyphenyl)-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2-(2,4-dihydroxyphenyl)-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2,4-bis(2-hydroxy-4-propyloxyphenyl)-6-(2,4-dimethylphenyl)-1,3,5-triazine; 2-(2-hydroxy-4-octyloxyphenyl)-4,6-bis(4-methylphenyl)-1,3,5-triazine; 2-(2-hydroxy-4-dodecyloxyphenyl)-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2-[2-hydroxy-4-(2-hydroxy-3-butyloxypropyloxy)phenyl]-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2-[2-hydroxy-4-(2-hydroxy-3-octyloxypropyloxy)phenyl]-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2-(2-hydroxy-4-tridecyloxyphenyl)-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2-[4-(dodecyloxy/tridecyloxy-2-hydroxypropoxy)-2-hydroxyphenyl]-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2-[2-hydroxy-4-(2-hydroxy-3-dodecyloxypropoxy)phenyl]-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine; 2-(2-hydroxy-4-hexyloxyphenyl)-4,6-diphenyl-1,3,5-triazine; 2-(2-hydroxy-4-methoxyphenyl)-4,6-diphenyl-1,3,5-triazine; 2,4,6-tris[2-hydroxy-4-(3-butoxy-2-hydroxypropoxy)phenyl]-1,3,5-triazine; 2-(2-hydroxyphenyl)-4-(4-methoxyphenyl)-6-phenyl-1,3,5-triazine; 2-{2-hydroxy-4-[3-(2-ethylhexyl-1-oxy)-2-hydroxypropyloxy]phenyl}-4,6-bis(2,4-dimethylphenyl)-1,3,5-triazine.

3. "Metal-deactivators" such as, for example: N,N'-di-phenyloxamide, N-salicylal-N'-salicyloyl-hydrazine, N,N'-bis(salicyloyl)hydrazine, N,N'-bis(3,5-di-t-butyl-4-hydroxyphenylpropionyl)hydrazine, 3-salicyloylamino-1,2,4-  
5 triazole, bis (benzylidene)oxallyl dihydrazide, oxanilide, isophthaloyl dihydrazide, sebacoyl bisphenylhydrazide, N,N'-diacetyladi-poyl dihydrazide, N,N'-bis(salicyloyl)oxallyl dihydrazide, N,N'-bis(salicyloyl)thiopropionyl dihydrazide.

10 4. Phosphites and phosphonites such as, for example: triphenyl phosphite, diphenyl alkyl phosphites, phenyl dialkyl phosphites, tris(nonylphenyl)phosphite, trilauryl phosphite, trioctadecyl phosphite, distearyl pentaerythritol diphosphite, tris(2,4-di-t-butylphenyl) phosphite,  
15 diisodecyl pentaerythritol diphosphite, bis(2,4-di-t-butylphenyl) pentaerythritol diphosphite, bis(2,6-di-t-butyl-4-methylphenyl)pentaerythritol diphosphite, diisodecylloxypentaerythritol diphosphite, bis(2,4-di-t-butyl-6-methylphenyl)pentaerythritol diphosphite, bis[2,4,6-  
20 tris(t-butylphenyl)]pentaerythritol diphosphite, tristearyl sorbitol triphosphite, tetrakis-(2,4-di-t-butylphenyl)-4,4'-diphenylenediphosphonite, 6-iso-octyloxy-2,4,8,10-tetra-t-butyl-12H-dibenzo-[d,g]-1,3,2-dioxaphosphocine, 6-fluoro-2,4,8,10-tetra-t-butyl-12-  
25 methyl-dibenzo[d,g]-1,3,2-dioxaphosphocine, bis-(2,4-di-

t-butyl-6-methylphenyl)methylphosphite, bis(2,4-di-t-butyl-6-methylphenyl)ethylphosphite; 2,2'2''-nitrido[triethyl-tris(3,3',5,5'-tetra-t-butyl-1,1'-biphenyl-2,2'-diyl)phosphite; 2-ethylhexyl-(3,3',5,5'-tetra-t-butyl-1,1'-biphenyl-2,2'-diyl)phosphite.

5     5. Hydroxylamines such as, for example: N,N-dibenzylhydroxylamine; N,N-diethylhydroxylamine; N,N-dioctylhydroxylamine; N,N-dilaurylhydroxylamine; N,N-ditetradecylhydroxylamine; N,N-dihexadecylhydroxylamine; N,N-dioctadecylhydroxylamine; N-hexadecyl-N-octadecylhydroxylamine; N-heptadecyl-N-octadecylhydroxylamine; N,N-dialkylhydroxylamines deriving from hydrogenated tallow amines.

15     6. Nitrons such as, for example: N-benzyl- $\alpha$ -phenyl-nitron; N-ethyl- $\alpha$ -methyl-nitron; N-octyl- $\alpha$ -heptyl-nitron; N-lauryl- $\alpha$ -undecyl-nitron; N-tetradecyl- $\alpha$ -tridecyl-nitron; N-hexadecyl- $\alpha$ -pentadecyl-nitron; N-octadecyl- $\alpha$ -heptadecyl-nitron; N-hexadecyl- $\alpha$ -heptadecyl-nitron; N-octadecyl- $\alpha$ -pentadecyl-nitron; N-heptadecyl- $\alpha$ -heptadecyl-nitron; N-octadecyl- $\alpha$ -hexadecyl-nitron; nitrons deriving from hydrogenated tallow amines.

20     7. Thiosynergizing agents such as, for example: dilauryl thiodipropionate; distearyl thiodipropionate.

25     8. Agents which are capable of destroying peroxides such as, for example, esters of  $\beta$ -thiodipropionic acid such as

lauryl, stearyl, myristyl or tridecyl esters, mercapto-benzimidazole or zinc salt of 2-mercaptobenzimidazole, zinc dibutyldithiocarbamate, dioctadecyldisulfide, pentaerythritol tetrakis( $\beta$ -dodecylmercapto)propionate.

5 9. Polyamide stabilizers such as, for example, copper salts combined with compounds of iodine and/or phosphorous, divalent manganese salts.

10. Basic co-stabilizers such as, for example: melamine, polyvinylpyrrolidone, dicyanodiamide, triallyl cyanurate,  
10 derivatives of urea, derivatives of hydrazine, amines, polyamides, polyurethanes, salts of alkaline metals and salts of earth-alkaline metals of fatty acids with a high molecular weight such as, for example, Ca-stearate, Zn-stearate, Mg-stearate, Mg-behenate, Na-ricinoleate, K-  
15 palmitate, antimonium-pyrocatecholate, tin-pyrocatecholate, zinc-pyrocatecholate.

11. Nucleating agents such as, for example: inorganic substances such as talc, metal oxides (for example, titanium dioxide or magnesium oxide), phosphates, carbonates  
20 or sulfates (preferably of earth-alkaline metals); organic compounds such as mono- or polycarboxylic acids and their salts (for example, 4-t-butylbenzoic acid, adipic acid, diphenylacetic acid, sodium succinate, sodium benzoate); polymeric compounds such as ionic copolymers  
25 ("ionomers").

12. Fillers and reinforcing agents such as, for example:  
calcium carbonate, silicates, glass fibres, glass beads,  
asbestos, talc, kaolin, mica, barium sulfate, metal ox-  
ides and hydroxides, carbon black, graphite, wood flour  
5 and flours or fibres of other natural products, synthetic  
fibres.

13. Other additives such as, for example: plasticizers,  
lubricants, emulsifying agents, rheological additives,  
catalysts, slip agents, optical brighteners, flame-  
10 retardants (for example bromurates, chlorurates, phos-  
phorates and phosphorous/halogen mixtures), antistatic  
agents, blowing agents.

14. Benzofuranones and indolinones such as, for example:  
3-[4-(2-acetoxyethoxy)phenyl]-5,7-di-t-butyl-benzofuran-  
15 2-one; 5,7-di-t-butyl-3-[4-(2-stearoyloxyethoxy)phenyl]  
benzofuran-2-one; 3,3'-bis[5,7-di-t-butyl-3-[4-(2-hydr-  
oxyethoxy)phenyl]benzofuran-2-one]; 5,7-di-t-butyl-3-(4-  
ethoxyphenyl)benzofuran-2-one; 3-(4-acetoxy-3,5-dimeth-  
ylphenyl)-5,7-di-t-butyl-benzofuran-2-one; 3-(3,5-di-  
20 methyl-4-pivaloyloxyphenyl)-5,7-di-t-butyl-benzofuran-2-  
one; or those described in U.S. patents 4,325,863,  
4,338,244, 5,175,312, 5,216,052 and 5,252,643; in German  
patents DE 4,316,611, 4,316,622 and 4,316,876; or in  
European patent applications Nr. 589,839 and 591,102.

25 Specific examples of stabilizers for organic poly-

mers useful for the purposes of the present invention selected from those listed above are:

- 1,3,5-tris(3,5-di-t-butyl-4-hydroxybenzyl)-2,4,6-trimethylbenzene (known under the trade-name of IRGANOX 5 1330 of Ciba);
- tetrakis[3-(3,5-di-t-butyl-4-hydroxyphenyl)propionyl-oxymethyl]methane, both in amorphous and crystalline form, (known under the trade-names of ANOX 20 AM and ANOX 20, respectively, of Great Lakes Chemical Corporation); 10
- octadecyl 3-(3',5',-di-t-butyl-4'-hydroxyphenyl)propionate (known under the trade-name of ANOX PP18 of Great Lakes Chemical Corporation);
- 2,2'-thiodiethylene bis[3-(3,5-di-t-butyl-4-hydroxy- 15 phenyl)propionate (known under the trade-name of ANOX 70 of Great Lakes Chemical Corporation);
- 1,3,5-tris(3,5-di-t-butyl-4-hydroxybenzyl)isocyanurate (known under the trade-name of ANOX IC-14 of Great Lakes Chemical Corporation);
- 20 - 2-hydroxy-4-methoxybenzophenone (known under the trade-name of LOWILITE 20 of Great Lakes Chemical Corporation);
- 2-hydroxy-4-n-octyloxybenzophenone (known under the trade-name of LOWILITE 22 of Great Lakes Chemical Corporation); 25

- polymethylpropyl-3-oxy-[4-(2,2,6,6-tetramethyl)piperidiny]siloxane (known under the trade-name of UVASIL 299 of Great Lakes Chemical Corporation);
- bis-(2,2,6,6-tetramethyl-4-piperidiny)sebacate (known  
5 under the trade-name of LOWILITE 77 of Great Lakes Chemical Corporation);
- bis-(1,2,2,6,6-pentamethyl-4-piperidiny)sebacate (known under the trade-name of LOWILITE 76 of Great Lakes Chemical Corporation);
- 10 - condensation product between 1-(2-hydroxyethyl)-2,2,6,6-tetra-4-hydroxypiperidine and succinic acid (known under the trade-name of LOWINOX 62 of Great Lakes Chemical Corporation);
- condensation product, linear or cyclic, between N,N'-  
15 bis(2,2,6,6-tetramethyl-4-piperidyl)hexamethylenediamine and 4-t-octylamino-2,6-dichloro-1,3,5-s-triazine (known under the trade-name of LOWINOX 94 of Great Lakes Chemical Corporation);
- tris(2,4-di-t-butylphenyl)phosphite (known under the  
20 trade-name of ALKANOX 240 of Great Lakes Chemical Corporation);
- bis(2,4-di-t-butylphenyl)pentaerythritol diphosphite (known under the trade-name of ALKANOX P-24 of Great Lakes Chemical Corporation);
- 25 - dilauryl thiodipropionate;



- distearyl thiodipropionate;
- esters of  $\beta$ -thiodipropionic acid such as lauryl, stearyl;
- N,N'-bis(3,5-di-t-butyl-4-hydroxyphenylpropionyl)hydrazine (known under the trade-name of LOWINOX MD 24).

Organic pigments which can be used for the purposes of the present invention are selected from organic pigments of the azo type, azomethines, anthraquinones, perilenes, dioxazines, thioindigo reds, quinacridones, phthalocyanines, blue indanthrones, carbazoles (for example, purple carbazole), isoindolinones, isoindolones, benzimidazolones, or their metal salts, etc.

Inorganic pigments which can be used for the purposes of the present invention are selected from metal oxides such as, for example, titanium dioxide, iron oxide of various colors, zinc oxide, carbon black, filler pigments such as, for example, talc, China clay, barites, carbonates, silicates, sulfosilicates, etc.

Dyes, a term herein also referring to bleaching agents, useful for the purposes of the present invention are selected from dyes which are soluble, insoluble or only slightly soluble in water.

Dyes soluble in water are, for example, acid dyes such as nitro dyes, aminoketones, ketone-imines, methines, nitrodiphenylamines, quinolines, aminonaphthoqui-

nones, coumarins, anthraquinones, azo dyes such as mono-azo or diazo dyes. These dyes contain one or more anionic groups soluble in water such as, for example, a carboxylic acid group or a sulfonic acid group and they are  
5 generally in the form of salts such as, for example, lithium, sodium, potassium or ammonium salts.

The above dyes can also be salts such as chlorides, sulfates, metasulfates, or -onium chlorides or metal halides such as, for example, tetrachlorozincates of azo  
10 dyes (monoazo, diazo or polyazo); anthraquinones, phthalocyanines, diarylmethane and triarylmethane; methine, polymethine and azomethine; thiazoles, ketone-imines, acridines, cyanines, nitro dyes, quinolines, benzimidazoles, xanthenes, azines, oxazines, thiazines and tri-  
15 azines which have at least one quaternary nitrogen in the molecule.

Dyes which are insoluble or only slightly soluble in water useful for the purposes of the present invention are selected from dyes containing sulfur, disperse dyes  
20 or vat dyes.

Disperse dyes are selected from nitro dyes, aminoketones, ketone-imines, methines, polymethines, diphenylamines, quinolines, benzimidazoles, xanthene, oxazines, aminonaphthoquinones, coumarins which do not contain car-  
25 boxylic acid or sulfonic acid groups and are, in particu-

lar, anthraquinones and azo dyes such as monoazo and diazo dyes.

Vat dyes are those applied to fabrics in dispersed solid form and, after development, are still present in a  
5 form which is insoluble in water.

In the mixtures of additives, object of the present invention, the stabilizers for organic polymers, organic or inorganic pigments and dyes are used in any ratio, depending on the end-use.

10 The above mixtures of additives are added to organic polymers. Examples of organic polymers to which they can be added are:

1. Polymers of mono-olefins and di-olefins such as, for example, polypropylene, polyisobutylene, polybut-1-ene,  
15 poly-4-methylpent-1-ene, polyisoprene or polybutadiene; as well as polymers of cyclo-olefins such as, for example, cyclopentene or norbornene; polyethylene (which can be optionally cross-linked) such as, for example, high density polyethylene (HDPE), high density and high molecular weight polyethylene (HDPE-HMW), high density and ultrahigh molecular weight polyethylene (HDPE-UHMW), medium density polyethylene (MDPE), low density polyethylene (LDPE), linear low density polyethylene (LLDPE), branched low density polyethylene (BLDPE), (VLDPE), (ULDPE).

Polyolefins such as, for example, the mono-olefins mentioned in the above paragraph, preferably polyethylene and polypropylene, can be prepared with various methods known in literature, preferably using the following meth-

5   ods:

- (a) radical polymerization (generally carried out at a high pressure and high temperature);
- (b) catalytic polymerization using a catalyst which normally contains one or more metals of groups IVb, Vb, 10   Vib or VIII of the Periodic Table. These metals generally have one or more binders such as, for example, oxides, halides, alcoholates, esters, ethers, amines, alkyls, alkenyls and/or aryls which can be  $\pi$ - or  $\sigma$ -coordinated. These metal complexes can be in free 15   form or supported on substrates such as, for example, activated magnesium chloride, titanium(III) chloride, alumina or silicon oxide. These catalysts can be soluble or insoluble in the polymerization medium. The catalysts can be used alone or in the presence of 20   other activators such as, for example, metal alkyls, metal hydrides, halides of metal alkyls, oxides of metal alkyls or metal alkyloxanes, these metals being elements belonging to groups Ia, IIa and/or IIIa of the Periodic Table. The activators can be conveniently 25   modified with other ester, ether, amine or

silyl-ether groups. These catalytic systems are usually called Phillips, Standard Oil Indiana, Ziegler(-Natta), TNZ (Du-Pont), metallocene or "single site catalyst" (SSC).

5 2. Mixtures of the polymers described under point (1) such as, for example, mixtures of polypropylene with polyisobutylene; mixtures of polypropylene with polyethylene (for example, PP/HDPE, PP/LDPE); mixtures of different types of polyethylene (for example, LDPE/  
10 HDPE).

3. Copolymers of mono-olefins and di-olefins with each other or with other vinyl monomers such as, for example, ethylene/propylene copolymers, linear low density polyethylene (LLDPE) and its mixtures with low density polyethylene (LDPE), propylene/but-1-ene copolymers, propylene/isobutylene copolymers, ethylene/but-1-ene copolymers, ethylene/hexene copolymers, ethylene/methylpentene copolymers, ethylene/heptene copolymers, ethylene/octene copolymers, propylene/butadiene copolymers, isobutylene/isoprene  
15 copolymers, ethylene/alkyl acrylate copolymers, ethylene/alkyl methacrylate copolymers, ethylene/vinyl acetate copolymers and their copolymers with carbon monoxide or ethylene/acrylic acid copolymers and their salts (ionomers) as well as terpolymers of ethylene with propylene  
20 and a diene such as, for example, hexadiene, dicyclopenta-

diene or ethylidene-norbornene; and also mixtures of said copolymers with each other or with the polymers cited under point (1) such as, for example, polypropylene/ethylene/propylene copolymers, LDPE/ethylene/vinyl acetate (EVA) copolymers, LDPE/ethylene/acrylic acid (EAA) copolymers, LLDPE/EVA, LLDPE/EAA, and alternating or random polyalkylene/carbon monoxide copolymers and their mixtures with other polymers such as, for example, polyamides.

10 4. Hydrocarbon resins (for example, C<sub>5</sub>-C<sub>9</sub>) comprising their hydrogenated modifications (for example, adhesive resins) and mixtures with polyalkylene and starch.

5. Polystyrene, poly(p-methylstyrene), poly( $\alpha$ -methylstyrene).

15 6. Copolymers of styrene or  $\alpha$ -methylstyrene with dienes or acrylic derivatives such as, for example, styrene/butadiene, styrene/acrylonitrile, styrene/alkyl methacrylate, styrene/butadiene/alkyl acrylate, styrene/butadiene/alkyl methacrylate, styrene/maleic anhydride, styrene/acrylonitrile/methyl acrylate; mixtures, having a high impact strength, between copolymers of styrene and another polymer such as, for example, a polyacrylate, a polymer of a diene or an ethylene/propylene/diene terpolymer, block copolymers of styrene such as, for example,

20 styrene/butadiene/styrene, styrene/isoprene/styrene, sty-

25

rene/ethylene/butylene/styrene or styrene/ethylene/propylene/styrene.

7. Grafted copolymers of styrene or of  $\alpha$ -methylstyrene such as, for example, styrene in polybutadiene, styrene in  
5 polybutadiene/styrene or polybutadiene/acrylonitrile copolymers; styrene and acrylonitrile (or methacrylonitrile) in polybutadiene; styrene, acrylonitrile and methylmethacrylate in polybutadiene; styrene and maleic anhydride in polybutadiene; styrene, acrylonitrile and maleic  
10 anhydride or maleimide in polybutadiene; styrene and maleimide in polybutadiene; styrene and alkylacrylates or alkylmethacrylates in polybutadiene; styrene and acrylonitrile in ethylene/propylene/diene terpolymers, styrene and acrylonitrile in polyalkyl acrylates or polyalkyl  
15 methacrylates, styrene and acrylonitrile in acrylate/butadiene copolymers, as well as mixtures of the copolymers listed above with the copolymers cited under point (6) such as, for example, mixtures of known copolymers such as ABS, MBS, ASA or AES.

20 8. Polymers containing halogens such as, for example, polychloroprene, chlorinated rubbers, chlorinated or brominated isobutylene-isoprene copolymers ("halobutyl rubber"), chlorinated or chlorosulfonated polyethylene, ethylene and chlorinated ethylene copolymers, homopolymers  
25 and copolymers of epichlorohydrin, in particular polymers

of vinyl compounds containing halogens such as, for example, polyvinyl chloride, polyvinylidene chloride, polyvinyl fluoride or polyvinylidene fluoride; and also their copolymers such as, for example, vinyl chloride/vinylidene chloride, vinyl chloride/vinyl acetate or vinylidene-chloride/vinyl acetate.

9. Polymers deriving from  $\alpha,\beta$ -unsaturated acids and their derivatives such as, for example, polyacrylates and polymethacrylates, polymethyl methacrylates, polyacrylamides and polyacrylonitriles, impact-modified with butyl acrylate.

10. Copolymers of monomers according to point (9) with each other or with other unsaturated monomers such as, for example, acrylonitrile/butadiene copolymers, acrylonitrile/alkyl acrylate copolymers, acrylonitrile/alkoxyalkyl acrylate copolymers or acrylonitrile/vinyl halide copolymers or acrylonitrile/alkyl methacrylate/butadiene terpolymers.

11. Polymers deriving from unsaturated alcohols and amines, or their acyl or acetal derivatives such as, for example, polyvinyl alcohol, polyvinyl acetate, polyvinyl stearate, polyvinyl benzoate, polyvinyl maleate, polyvinyl butyral, polyallyl phthalate or polyallyl melamine; and also their copolymers with the olefins listed under point (1).



12. Homopolymers and copolymers of open-chain ethers or cyclic ethers such as, for example, polyalkylene glycols, polyethylene oxide, polypropylene oxide, or copolymers of the compounds described above with bis-glycidyl ethers.
- 5 13. Polyacetals such as, for example, polyoxymethylene and those polyoxymethylenes containing comonomers, for example, ethylene oxide; polyacetals modified with thermoplastic polyurethanes, acrylates or MBS.
14. Polyphenylene oxides and sulfides and their mixtures  
10 with styrene polymers or polyamides.
15. Polyurethanes deriving from hydroxyl-terminated polyethers, polyesters or polybutadienes on the one hand and aliphatic or aromatic polyisocyanates on the other, as well as their precursors.
- 15 16. Polyamides and copolyamides deriving from diamines and dicarboxylic acids and/or aminocarboxylic acids or from the corresponding lactams such as, for example, polyamide 4, polyamide 6, polyamide 6/6, 6/10, 6/9, 6/12, 4/6, 12/12, polyamide 11, polyamide 12, aromatic polyam-  
20 ides obtained starting from m-xylene diamine and adipic acid; polyamides prepared from hexamethylenediamine and isophthalic and/or terephthalic acid and with or without an elastomer as modifier, for example, poly-2,4,4-trimethylhexamethylene terephthalamide or poly-m-phenylene isoph-  
25 thalamide; and also block copolymers of the above polyam-

ides with polyolefins, olefinic copolymers, ionomers or elastomers chemically bound or grafted; or with polyethers such as, for example, polyethylene glycol, polypropylene glycol or polytetramethylene glycol; as well as polyamides  
5 or copolyamides modified with EPDM or ABS; and polyamides condensed during processing ("RIM polyamide system").

17. Polyureas, polyimides, polyamide-imides, polyetherimides, polyesterimides, polyhydantoins, and polybenzimidazoles.

10 18. Polyesters deriving from dicarboxylic acids and diols and/or from hydroxycarboxylic acids or from the corresponding lactones such as, for example, polyethylene terephthalate, polybutylene terephthalate, poly-1,4-dimethylolcyclohexane terephthalate and polyhydroxybenzoates, as  
15 well as block copolyether esters deriving from polyethers with hydroxyl-terminated groups; and also polyesters modified with polycarbonates or MBS.

19. Polycarbonates and polyester carbonates.

20. Polysulfones, polyethersulfones and polyetherketones.

20 21. Cross-linked polymers deriving from aldehydes on the one hand and from phenols, urea and melamines on the other, such as, for example, phenol/formaldehyde resins, urea/formaldehyde resins and melamine/formaldehyde resins.

25 22. Drying or non-drying alkyd resins.

23. Resins based on unsaturated polyesters deriving from copolyesters of dicarboxylic acids saturated and unsaturated with polyhydric alcohols and vinyl compounds as cross-linking agents, and also the above resins containing  
5 halogens and having a good flame-resistance.

24. Cross-linkable acrylic resins deriving from substituted acrylates such as, for example, epoxy acrylates, urethane acrylates or polyester acrylates.

25. Alkyd resins, resins based on polyesters or acrylated  
10 resins cross-linked with melamine resins, resins based on urea, resins based on isocyanates, resins based on isocyanurates, resins based on polyisocyanates or epoxy resins.

26. Cross-linked epoxy resins deriving from aliphatic,  
15 cycloaliphatic, heterocyclic or aromatic glycidyl compounds such as, for example, products of diglycidyl ethers of bisphenol A and bisphenol F, which are cross-linked with the usual cross-linking agents such as, for example, anhydrides or amines, in the presence of or without accelerating agents.  
20

27. Natural polymers such as, for example, cellulose, rubber, gelatin, and their derivatives chemically modified to give homologous polymers such as, for example, cellulose acetates, propionates and butyrates, or cellulose

ethers such as, for example, methyl-cellulose; as well as hydrocarbon resins ("rosins") and their derivatives.

28. Mixtures of the above polymers ("polyblends") such as, for example, PP/EPDM, polyamides/EPDM or ABS, PVC/EVA,  
5 PVC/ABS, PVC/MBS, PC/ABS, PBTP/ABS, PC/ASA, PC/PBT, PVC/CPE, PVC/acrylates, POM/thermoplastic PUR, PC/thermoplastic PUR, POM/acrylates, POM/MBS, PPO/HIPS, PPO/PA 6.6 and copolymers, PA/HDPE, PA/PP, PA/PPO, PBT/PC/ABS, PBT/PET/PC.

10 29. Natural or synthetic organic materials which are pure monomeric compounds or mixtures of said compounds, such as, for example, mineral oils, animal or vegetable oils, fats or waxes, oils, fats or waxes based on synthetic esters (for example, phthalates, adipates, phosphates, trimellitates), as well as mixtures of synthetic  
15 esters with mineral oils in any weight ratio, in particular those used in spinning compositions, as well as aqueous emulsions of said organic materials.

30. Aqueous emulsions of natural or synthetic rubbers  
20 such as, for example, natural latex or latexes based on carboxylated styrene-butadiene copolymers.

The present invention also relates to polymeric compositions containing an organic polymer and an effective quantity of one of the above mixtures of additives.

25 The mixtures of additives, object of the present in-

vention, are particularly useful in the stabilization and dyeing of organic polymers selected from those listed above.

A further object of the present invention relates to  
5 the end-products obtained from the processing of the above polymeric compositions.

The mixtures of additives, object of the present invention, are added to the organic polymers to be stabilized in a quantity ranging from 0.01% to 5% with respect  
10 to the total weight of the polymer to be stabilized, preferably from 0.05% to 3%, even more preferably from 0.1% to 1%.

The mixtures of additives, object of the present invention, can be incorporated into the organic polymer to  
15 be stabilized by means of the known techniques.

The mixtures of additives, object of the present invention, are obtained, as already mentioned, by the extrusion of powder mixtures of the different components, operating at such a temperature as to ensure that at  
20 least a small part of the lowest-melting component melts.

A solid "spaghetto" is thus obtained which, after appropriate cooling, can be granulated by cutting at the extruder head or by subsequent fragmentation.

The molten part of the lowest-melting component, on  
25 resolidifying, acts as a gluing agent for the remaining

components: in this way the solid "spaghetti" is formed and is subsequently cooled and cut as described above.

Some illustrative but non-limiting examples are provided for a better understanding of the present invention  
5 and for its embodiment.

#### EXAMPLE 1

22.98 g of octadecyl 3-(3',5'-di-t-butyl-4'-hydroxy-phenyl)propionate (known under the trade-name of ANOX PP18 of Great Lakes Chemical Corporation), 61.30 g of  
10 tris(2,4-di-t-butylphenyl)phosphite (known under the trade-name of ALKANOX 240 of Great Lakes Chemical Corporation), 114.94 g of calcium stearate and 0.78 g of "Ultramarine Violet" of Whittaker, Clark & Daniels, are charged into a planetary powder mixer.

15 The above homogenized mixture is fed to a Brabender laboratory extruder having a screw feeder of 475 mm in length, 19 mm in diameter and with a compression ratio of 1:4, which has the possibility of differentiated heating in four different zones of the screw feeder. The mixture  
20 is extruded through a 2.5 mm diameter hole, with a rotation rate of the screw feeder of 90 rpm and a temperature profile of 150°C, 135°C, 110°C, 130°C.

A "spaghetti" is obtained which, after cooling to room temperature, is cut up into violet granules, not  
25 containing powders, having dimensions of about 2-2.5 mm.

## CLAIMS

1. Mixtures of additives in granular form comprising:
  - one or more stabilizers for organic polymers;
  - one or more organic or inorganic pigments;
  - 5       and/or
  - one or more dyes;obtained by extrusion at a temperature capable of enabling the partial or total melting of the lowest-melting component.
- 10   2. The mixtures of additives in granular form according to claim 1, wherein the stabilizers for organic polymers are selected from the following groups: antioxidants, ultraviolet-ray and light stabilizers, metal-deactivators, phosphites and phosphonites, hydroxylamines, nitrons, thiosynergizing agents,
- 15       agents capable of destroying peroxides, polyamide stabilizers, basic co-stabilizers, nucleating agents, fillers and reinforcing agents, other additives, benzofuranones and indolinones.
- 20   3. The mixtures of additives in granular form according to claim 2, wherein the antioxidants are selected from alkylated monophenols, alkylthiomethylphenols, hydroquinones and alkylated hydroquinones, tocopherols, hydroxylated thiodiphenyl ethers, alkylidene-
- 25       bisphenols, benzyl compounds containing O, N or S,

hydroxybenzylated malonates, aromatic hydroxybenzyl compounds, triazine compounds, benzylphosphonates, acylaminophenols, esters of  $\beta$ -(3,5-di-t-butyl-4-hydroxyphenyl)propionic acid with monohydric or

5 polyhydric alcohols, esters of  $\beta$ -(5-di-t-butyl-4-hydroxyphenyl)propionic acid with monohydric or polyhydric alcohols, esters of  $\beta$ -(3,5-dicyclohexyl-4-hydroxyphenyl)propionic acid with monohydric or

10 polyhydric alcohols, esters of 3,5-di-t-butyl-4-hydroxyphenyl acetic acid with monohydric or polyhydric alcohols, amides of  $\beta$ -(3,5-di-t-butyl-4-hydroxyphenyl)propionic acid, ascorbic acid, aminic antioxidants.

4. The mixtures of additives in granular form according

15 to claim 2, wherein the ultraviolet ray and light stabilizers are selected from derivatives of 2-(2'-hydroxyphenyl)benzotriazoles, derivatives of 2-hydroxybenzophenones, esters of benzoic acids optionally substituted, acrylates, nickel compounds,

20 sterically hindered amines and their N-alkoxy derivatives, oxamides, 2-(2-hydroxyphenyl)-1,3,5-triazine.

5. The mixtures of additives in granular form according

25 to claim 2, wherein the other additives are selected from plasticizers, lubricants, emulsifying agents,



1  
rheological additives, catalysts, slip agents, optical brighteners, flame-retardants (bromurates, chlorurates, phosphorates and phosphorous/halogen mixtures), antistatic agents, blowing agents.

- 5 6. The mixtures of additives in granular form according to claim 1, wherein the organic pigments are selected from organic pigments of the azo type, azomethines, anthraquinones, perilenes, dioxazines, thioindigo reds, quinacridones, phthalocyanines, 10 blue indanthrones, carbazoles, isoindolinones, isoindolones, benzimidazolines, or their metal salts.
- 15 7. The mixtures of additives in granular form according to claim 1, wherein the inorganic pigments are selected from metal oxides such as titanium dioxide, iron oxide of various colors, zinc oxide, carbon black, filler pigments such as talc, China clay, barites, carbonates, silicates, sulfosilicates.
- 20 8. The mixtures of additives in granular form according to claim 1, wherein the dyes, a term which herein also indicates bleaching agents, are selected from dyes which are soluble, insoluble or only slightly soluble in water.
- 25 9. The mixtures of additives in granular form according to claim 8, wherein the dyes which are soluble in

water are selected from acid dyes such as nitro dyes, aminoketones, ketone-imines, methines, nitro-diphenylamines, quinolines, aminonaphthoquinones, coumarins, anthroquinones, azo dyes such as monoazo or diazo dyes.

- 5
10. The mixtures of additives in granular form according to claim 9, wherein the dyes which are soluble in water contain one or more anionic groups soluble in water such as a carboxylic acid group or a sulfonic acid group and they are generally in the form of salts such as lithium, sodium, potassium or ammonium salts.
- 10
11. The mixtures of additives in granular form according to claim 8, wherein the dyes which are soluble in water are salts such as sulfates, metasulfates, or -onium chlorides or metal halides such as tetrachlorozincates of azo dyes (monoazo, diazo or polyazo); anthraquinones, phthalocyanines, diarylmethane and triarylmethane; methine, polymethine and azomethine;
- 15
- 20 thiazoles, ketone-imines, acridines, cyanines, nitro dyes, quinolines, benzimidazoles, xanthenes, azines, oxazines, thiazines and triazines which have at least one quaternary nitrogen in the molecule.
12. The mixtures of additives in granular form according to claim 1, wherein the dyes which are insoluble or
- 25

only slightly soluble in water are selected from dyes containing sulfur, disperse dyes or vat dyes.

13. The mixtures of additives in granular form according to claim 12, wherein the disperse dyes are selected from nitro dyes, aminoketones, ketone-imines, methi-  
5 nes, polymethines, diphenylamines, quinolines, benzimidazoles, xanthene, oxazines, aminonaphthoquinones, coumarins which do not contain carboxylic acid or sulfonic acid groups and are, in particular, anthraquinones and azo dyes such as monoazo and di-  
10 azo dyes.

14. The mixtures of additives in granular form according to claim 12, wherein the vat dyes are those applied to fabrics in dispersed solid form and, after devel-  
15 opment, are still present in a form which is insoluble in water.

15. Use of the mixtures of additives according to any of the previous claims in the stabilization and dyeing of organic polymers.

20 16. Polymeric compositions containing an organic polymer and an effective quantity of one of the mixtures of additives according to any of the previous claims.

17. End-products obtained from the processing of the polymeric compositions according to claim 16.

Abstract

Mixtures of additives in granular form comprising:

- 10    - one or more stabilizers for organic polymers;  
      - one or more organic or inorganic pigments; and/or  
      - one or more dyes;

obtained by extrusion at a temperature capable of enabling the partial or total melting of the lowest-melting  
15    component.

The above mixtures can be used in the stabilization and dyeing of organic polymers.